

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005580**Date Inspected:** 14-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** N/A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Erik Prue was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA Inspector observed and/or found the following:

Deck Panel repair area: QA inspector performed visual weld inspection on closed rib partial joint penetration welds, on production panels DP-302-001, DP489-001, DP491-001, DP193-001, DP084-001, and DP111-002 after ZPMC and ABF acceptable visual inspection. Visual weld inspection for deck panels DP-302-001, DP489-001, DP491-001, DP193-001, and DP111-002 appear to be in compliance with AWS D1.5 (02) and the contract documents. Deck Panel DP084-001 weld #1 visual weld inspection revealed approximately 3 meters of weld overlap at various locations. QA Inspector informed ZPMC deck panel repair foreman Mr. Nu Boa Qing of the area of overlap. Mr. Nu Boa Qing concurred with QA Inspector's findings and will repair areas marked. QA Inspector created segment trackers for lifts 1BW, 2AE, 2AW, 2BE, and 2BW. Segment Trackers contain sub assembly and segment assembly drawings and weld maps for tracking of Nondestructive testing completion and Quality Control (QC) green tagging by ABF and ZPMC.

Unless otherwise noted, all work observed on this date appears to be in general compliance with the applicable contract documents.

**Summary of Conversations:**

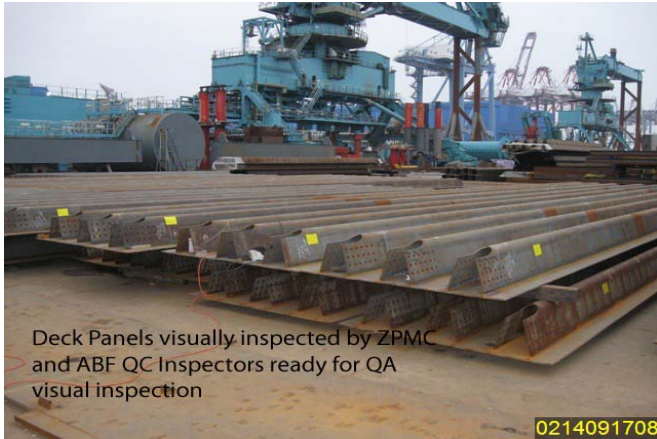
No significant conversations this day.

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# WELDING INSPECTION REPORT

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SFOBB QA VERIFICATION TAG  
IN-PROCESS

Tag No. 004020

UBASSEMBLY D0489-021

INSPECTIONS				REPAIRS			
	ZPMC	ABF	CT		ZPMC	ABF	CT
FW	Seen Rg	Seen Rg	Seen Rg	CWR			
UT				HSR			
MT				NCR			
RT							

In process yellow tag signed by ZPMC QC, ABF QC, and Caltrans QA Inspectors for visual inspection.

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## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prue,Erik	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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